

Work Order ID 50230

July 14, 2009 10:27:36 AM

Page 1

Item ID: D2175-2

Accept

Revision ID: E

Item Name: Angle RH

Start Date: 7/15/09 Start Qty: 10.00

Required Date: 7/15/09 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 09-07-15 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2175

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2175 ☐ Dwg Rev: E ☐ Prog Rev: E ☐ 2-
Deburr if necessary

HB 9-7-22

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-7-22

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> S or 4/22

(+12)

4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

• NOTE: Date & initial all entries

Work Order ID 50230

July 14, 2009 10:27:36 AM



Page 2

Item ID: D2175-2

Accept



Setup Start



Revision ID: E

Stop



Item Name: Angle RH

Start Date: 7/15/09

Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

Debur Stack

u/a S

0.00

Small Fab

140

0.00



Brake NC

NC BRAKE

Memo

Form as per Dwg D2175

SB 09/07/22

0.00

Brake NC

12 P

150

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

⇒ S 09/07/22

(+12) P

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 50230

July 14, 2009 10:27:36 AM



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Item ID: D2175-2

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Setup Start



Revision ID: E

Stop



Item Name: Angle RH

Start Date: 7/15/09

Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QS1005 4.1

0.00

BR 09-07-23

12



HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

SB 09/07/23 12



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: CA

0.00

SB 09/07/23 12



Packaging

Memo

0.00

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 50230

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Page 4

Item ID: D2175-2

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Setup Start



Revision ID: E

Stop



Item Name: Angle RH

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/27

MF 09-07-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 10:27:36 AM

Work Order ID: 50230



Parent Item: D2175-2RevE



Parent Item Name: Angle RH

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M2024T3S.063 | | Purchased | No | | | 100 | sf | 163.2716 | 4.9705 | | | |



2024-T3 .063 sheet



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 163.2715789 | |
| 102942 | 1.5 | |
| 105916 | 3.69 | |
| 106223 | 1.47 | |
| 109463 | 24.2 | |
| 110980 | 15.45 | |
| 111787 | 114.961579 | |
| 19059 | 2 | |

110980 189-7-22

(12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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• **NOTE:** Date & initial all entries

| | | | |
|--|--|---------------------|------------|
| DART AEROSPACE LTD | | Work Order: | 50230 |
| Description: Angle | | Part Number: | D2175-1/-2 |
| Inspection Dwg: D2175 Rev: E | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 12.650 | +/-0.010 | 12.650 | Q | | | |
| R0.35 | +/-0.030 | .35 | Q | | | |
| 2.915 | +/-0.010 | 2.918 | Q | | | |
| 50° | +/-0.5° | 50° | Q | | | |
| 0.300 | +/-0.010 | .300 | Q | | | |
| 1.050 Pitch | +/-0.010 | 1.049 | Q | | | |
| 10.500 | +/-0.010 | 10.493 | Q | | | |
| 11.550 | +/-0.010 | 11.548 | Q | | | |
| 0.550 | +/-0.010 | .548 | Q | | | |
| 0.900 | +/-0.010 | .900 | Q | | | |
| 0.063 thick | +/-0.010 | .063 | Q | | | |
| Grain Direction | N/A | | Q | | | |
| Ø0.128 | +0.005/-0.001 | .131 | Q | | | |
| Ø0.172 | +0.005/-0.001 | .174 | Q | | | |
| | | | | | | |
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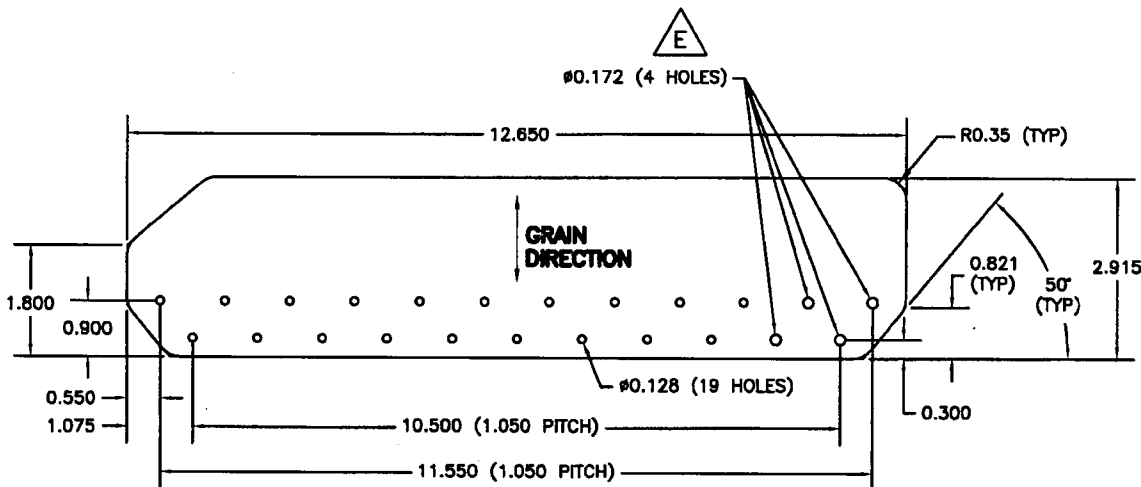
| | | | |
|------------------------|-----------------------|----------------------------|-----|
| Measured by: AB | Audited by: S | Prototype Approval: | N/A |
| Date: 4-7-22 | Date: 05/09/22 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|------------|----------|
| A | 04.08.12 | New Issue | KJ/JLM | |
| B | 07.03.23 | Dimensions revised per Dwg rev. E | KJ/JLM | |

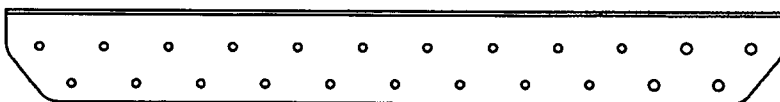
DART

RELEASED
06/10/13

| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|------------------|-------------------------|---|--------------|
| RF | CE | DRAWING NO. | REV. E |
| CHECKED PH | APPROVED [Signature] | D2175 | SHEET 1 OF 1 |
| DATE 06.09.25 | TITLE ANGLE | SCALE 1:3 | |
| A | 95.10.25 | NEW ISSUE | |
| B | 96.01.18 | CHANGED DIMENSION | |
| C | 00.09.11 | UPDATE FINISH SPEC | |
| D | 04.06.03 | RE-DESIGN | |
| E | 06.09.25 | INC HOLE DIA TO Ø0.172, 4 HOLES | |



D2175-1F FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50230

NOTES: MF 09-07-15

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES